

ASAP

Work Order ID 94256

94256

Tuesday, December 04, 2012 8:30:10 AM

Item ID: D3705-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: MAIN PANEL

Stop *NS2*

Start Date: 12/4/2012 Start Qty: 2.00

1
*1*2

Required Date: 12/6/2012 Req'd Qty: 1.00

Cust Item ID:

Customer:

PRELIMINARY ISS

Reference:

Approvals:

Process Plan: MF

Date: 12-12-04

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3705

PE1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3705

Dwg Rev: PE1

Prog Rev: PE1

grain direction

2- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2 0 Jm 12-12-4
2 0 Jm 12-12-4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | |
|--|-------------|-------------|---|---|--------------------------|---|------------------------|---------------------|--|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Work Order ID 94256

94256

Page 2

Tuesday, December 04, 2012 8:30:10 AM

Item ID: D3705-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: MAIN PANEL
 Start Date: 12/4/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/6/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|--|---------|--------|--------------|---------------|---------------|------------------|---------------------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 DAS 15 9-89 0.00 121204 | | | | 2 | | | |
| 130 *130* Small Fab Small Fab Small Fab | Small Fab Memo 1-COUNTER SINK AS PER DWG 2- BEND AS PER DWG D3705 | 0.00 0.00 | | | | 2x | | | EB 12/12/04 B 12/12/04 |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 DAS 15 9-89 0.00 | | | | 2 | | | inspect as per DWG PEI |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|-------------|-------------|---|---|--------------------------|---|------------------------|---------------------|--|--|---|
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| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

94256

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/4/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/6/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

Identify as per dwg & Stock Location: over

0.00

150

Memo

0.00

Packaging

Packaging

QC21- Final Inspection - Work Order Release

0.00

160

Memo

0.00

QC

Quality Control

POSITIVE RECALL

EFFECTIVE 12/20/71 AUTH

RELEASED _____ DATE _____

mf
12-12-05

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|---|--|

Picklist Print

Tuesday, December 04, 2012 8:30:09 AM

Page 1

Work Order ID: 94256

Parent Item: D3705-1

Parent Item Name: MAIN PANEL

Start Date: 12/4/2012

Required Date: 12/6/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-01-30 new issue EC verified by:DD
 IPP Rev:B 09-01-09 rev.C as per dwg DD verified by:EC
 IPP Rev:C as per dwg RevD DD 10.04.27 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6S.080
 6061-T6 .080 Sheet

Purchased

No

100

sf

295.5843

2.16

2.2736842
 4.6/sf

Jm 12-12-4

Location

Loc Qty

Loc Code

MAT021

295.584316

117285

0.124316

119766

20.66

120096

84.4

123279

190.4

123279

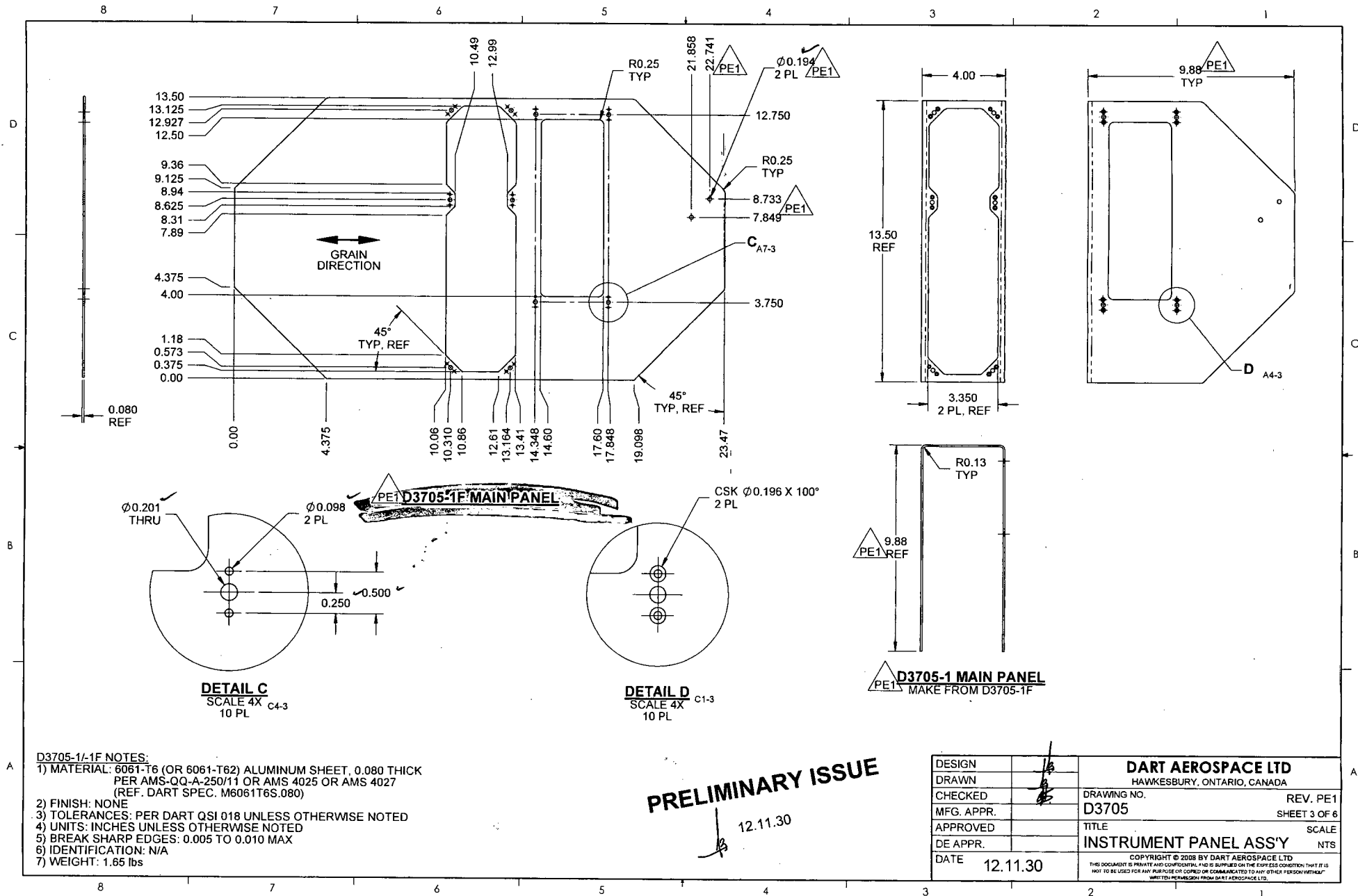
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | |
|--|------|------|---|---|----------------------|---|----------------|--------------|--|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | | |
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| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | |
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| Material <input type="checkbox"/> | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |



D3705-1F-1F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.65 lbs

PRELIMINARY ISSUE

12.11.30

| | | | |
|---|----------|--|------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. PE |
| MFG. APPR. | | D3705 | SHEET 3 OF |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | INSTRUMENT PANEL ASS'Y | NTS |
| DATE | 12.11.30 | COPYRIGHT © 2008 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
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| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
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| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

| | | |
|--|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 94256 |
| Description: Main Panel | | Part Number: D3705-1 |
| Inspection Dwg: D3705 Rev: PE1 | | Page 1 of 1/2 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------|------------------|--------|--------|----------------------|----------|
| Ø 0.098" | +0.004" -0.001" | 0.100" | - | | V | Jkmo1 |
| Ø 0.201" | +0.005" -0.001" | 0.204" | - | | V | " |
| 0.250" | +0.005" -0.001" | 0.250" | - | | V | " |
| 0.500" | +0.006" -0.001" | 0.505" | - | | V | " |
| Ø 0.194" | +0.005" -0.001" | 0.197" | - | | V | " |
| 0.080" | +/- 0.010" | 0.078" | - | | V | " |
| 0.375" | +/- 0.010" | 0.380" | - | | V | " |
| 0.573" | +/- 0.010" | 0.577" | - | | V | " |
| 1.18" | +/- 0.030" | 1.18" | - | | V | " |
| 4.001" | +/- 0.030" | 4.003" | - | | V | " |
| 4.375" | +/- 0.010" | 4.375" | - | | V | " |
| 7.89" | +/- 0.030" | 7.89" | - | | V | " |
| 8.31" | +/- 0.030" | 8.31" | - | | V | Producer |
| 8.625" | +/- 0.020" | 8.623" | - | | V | " |
| 8.94" | +/- 0.030" | 8.94" | - | | V | " |
| 9.125" | +/- 0.010" | 9.125" | - | | V | " |
| 9.36" | +/- 0.030" | 9.36" | - | | V | " |
| 12.50" | +/- 0.030" | 12.50" | - | | T | " |
| 12.927" | +/- 0.010" | 12.927" | - | | T | Jkmo6 |
| 13.125" | +/- 0.010" | 13.125" | - | | T | " |
| 13.50" | +/- 0.030" | 13.50" | - | | T | " |
| 10.49" | +/- 0.030" | 10.484" | - | | V | Producer |
| 12.99" | +/- 0.030" | 12.99" | - | | T | Jkmo6 |
| 21.850" | +/- 0.020" | 21.858" | - | | T | " |
| 22.741" | +/- 0.020" | 22.741" | - | | T | " |
| 12.750" | +/- 0.010" | 12.750" | - | | T | " |
| 8.733" | +/- 0.020" | 8.735" | - | | V | Producer |
| 7.849" | +/- 0.010" | 7.850" | - | | V | " |
| 3.750" | +/- 0.020" | 3.753" | - | | V | Jkmo6 |
| 4.375" | +/- 0.020" | 4.379" | - | | V | " |
| 10.06" | +/- 0.030" | 10.062" | - | | V | Producer |
| 10.310" | +/- 0.030" | 10.310" | - | | V | " |
| 10.86" | +/- 0.030" | 10.860" | - | | V | " |
| 12.61" | +/- 0.030" | 12.61" | - | | T | Jkmo6 |

| | | |
|---------------------------|--------------------------------|------------------------------|
| Measured by: JS JM | Audited by: (Signature) | Preliminary Approval: |
| Date: 12-12-4 | Date: 12-12-04 | Date: |

Receiving Report

Date: 12/10/10

Batch No: M/23279

Supplier: TITXGOSKINUPA

Dart P/O: 18068

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: DA Yes ☐ No ☒ N/A ☐
 QC6 Inspection 19 12/10/11 Yes ☐ No ☒ N/A ☐
 Work Order 85 N/A ☒

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|-------------|--------------|------------------|-------------------|-------------------|----------------|----------|
| M600176 | 80-375X0.100 | 318 | 36 | 0 | 12 | |
| M30451860 | | 192 | 160 | 0 | 32 | |
| M2024 | FS3.0190 | 48 | 0 | 0 | 48 | |

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 12/10/10
 Date [Signature]
 Received/Costing [Signature]
 Initial [Signature]

Location _____

| Purchase Order ID/ Curr Type | Line Nbr/ Insp Req | Project ID | Reference/ Description/ Cert Std | PO U/M / Stock U/M | Required Date Required Qty | Recv Date/ Recv Emp | Recv Qty (PO U/M) | Cost Per Unit/ Recv Value | Inspected Qty/ Rejected Qty (PO U/M) | MRB Qty/ MRB Reject Qty | Book Amt |
|--|-----------------------|------------|--|-----------------------|-------------------------------|------------------------|----------------------|------------------------------|--|----------------------------|------------|
| VendorID/Vendor Name VC-COP001 Thyssenkrupp Materials CA Ltd | | | | | | | | | | | |
| PO18068 | 8 | | M6061T6B00750X00 f 125 | | 10/10/2012 | 10/10/2012 | 100.0000 | \$0.36 | 0.0000 | 0 | \$36.11 |
| CAD | No | | 6061-T6 Bar .750 x f 125 | | 100.0000 | DESJ02 | | \$36.11 | 0.0000 | 0 | |
| | | | 123279 | | | | | | | | |
| | 9 | | M6061T6B1.000X02. f 000 | | 10/10/2012 | 10/10/2012 | 24.0000 | \$4.92 | 0.0000 | 0 | \$117.98 |
| | No | | 6061-T6 Bar 1.00 x f 2.00 | | 24.0000 | DESJ02 | | \$117.98 | 0.0000 | 0 | |
| | | | 123279 | | | | | | | | |
| | 10 | | M6061T6B0.625X01. f 500 | | 10/10/2012 | 10/10/2012 | 12.0000 | \$2.24 | 0.0000 | 0 | \$26.85 |
| | No | | 6061-T6 Bar .625 x f 1.50 | | 12.0000 | DESJ02 | | \$26.85 | 0.0000 | 0 | |
| | | | 123279 | | | | | | | | |
| | 11 | | M6061T6B0.187X04. f 000 | | 10/10/2012 | 10/10/2012 | 60.0000 | \$1.93 | 0.0000 | 0 | \$115.95 |
| | No | | 6061-T6 Bar .187 x f 4.00 | | 60.0000 | DESJ02 | | \$115.95 | 0.0000 | 0 | |
| | | | 123279 | | | | | | | | |
| | 12 | | M6061T6B2.000X02. f 250 | | 10/10/2012 | 10/10/2012 | 12.0000 | \$11.75 | 0.0000 | 0 | \$140.97 |
| | No | | 6061-T6 Bar 2.00 x f 2.25 | | 12.0000 | DESJ02 | | \$140.97 | 0.0000 | 0 | |
| | | | 123279 | | | | | | | | |
| | 13 | | M6061T6S.080 sf | | 10/10/2012 | 10/10/2012 | 288.0000 | \$2.72 | 0.0000 | 0 | \$783.98 |
| | No | | 6061-T6 .080 Sheet sf | | 288.0000 | DESJ02 | | \$783.98 | 0.0000 | 0 | |
| | | | 123279 | | | | | | | | |
| | 14 | | M6061T6S.090 sf | | 10/10/2012 | 10/10/2012 | 96.0000 | \$3.06 | 0.0000 | 0 | \$293.99 |
| | No | | 6061-T6 .090 Sheet sf | | 96.0000 | DESJ02 | | \$293.99 | 0.0000 | 0 | |
| | | | 123279 | | | | | | | | |
| | 15 | | M6061T6S.125 sf | | 10/10/2012 | 10/10/2012 | 144.0000 | \$4.20 | 0.0000 | 0 | \$604.72 |
| | No | | 6061-T6 .125 Sheet sf | | 144.0000 | DESJ02 | | \$604.72 | 0.0000 | 0 | |
| | | | 123279 | | | | | | | | |
| Total Received Quantity: | | | | | | | | | | | 1,072.0000 |
| Total Qty to Inspect (PO U/M): | | | | | | | | | | | 0.0000 |
| Total Reject Quantity: | | | | | | | | | | | 0.0000 |
| Total Receipt Value: | | | | | | | | | | | \$3,412.59 |
| Total Balance Due Quantity: | | | | | | | | | | | 44.0000 |

B I L L O F L A D I N G

No: PEC 789038

Ship From:
 THYSSENKRUPP MATERIALS NA
 2821 LANGSTAFF ROAD
 CONCORD, ONTARIO L4K 5C6
 Tel: 905 669 9444 Fax: 9057389033

Ship Date 09Oct12 at 13:18 From PFW
 Probill
 Via VIM TRANSFER
 FOB CONCORD
 Frt PREPAID
 Route 0- 0 Manifest
 Vhcle Trailer
 Slp STAN IVERS (905-532-1350)
 Sold To: (20115)
 DART AEROSPACE

Ship To: (1)
 DART AEROSPACE

B I L L O F L A D I N G

| Heat Number | Tag No | Quantity | PCS | Wt LBS |
|-------------|--------|----------|-----|--------|
| 201214546 | 111528 | 12 FT | 1 | 14 |

11) Our Order PEC-497102- 11 Your PO # 18068
 ALUMINUM FLAT BAR 6061-T6511
 .187" x 4.00" X 240.0000"

| Heat Number | Tag No |
|-------------|--------|
| HK717 205 | 111487 |

MTR'S
 Quantity
 60 FT

| PCS | Wt LBS |
|-----|--------|
| 3 | 52 |

12) Our Order PEC-497102- 12 Your PO # 18068
 ALUMINUM FLAT BAR 6061-T6511
 2.00" x 2.50" X 144.0000"

| Heat Number | Tag No |
|-------------|--------|
| HK118 102 | 111529 |

MTR'S
 Quantity
 12 FT

| PCS | Wt LBS |
|-----|--------|
| 1 | 70 |

13) Our Order PEC-497102- 13 Your PO # 18068
 ALUMINUM SHEET 6061 T6
 .0810 Nom X 48.0000" X 144.0000"

| Heat Number | Tag No |
|-------------|--------|
| 25872/01/00 | 111612 |

MTR'S
 Quantity
 288.00 SFT

| PCS | Wt LBS |
|-----|--------|
| 6 | 315 |

14) Our Order PEC-497102- 14 Your PO # 18068
 ALUMINUM SHEET 6061 T6
 .0910 Nom X 48.0000" X 144.0000"

| Heat Number | Tag No |
|-------------|--------|
| 27049/01/00 | 111614 |

MTR'S

Quantity
 96.00 SFT

| PCS | Wt LBS |
|-----|--------|
| 2 | 119 |

15) Our Order PEC-497102- 15 Your PO # 18068
 ALUMINUM SHEET 6061 T6
 .1250 Nom X 48.0000" X 144.0000"

| Heat Number | Tag No |
|-------------|--------|
| 25875/01/00 | 111615 |

MTR'S

Quantity
 144.00 SFT

| PCS | Wt LBS |
|-----|--------|
| 3 | 251 |

| TOTAL: | Tags | PCS | LBS |
|--------|------|-----|------|
| | 16 | 43 | 1437 |

Page: 3Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE

RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY.

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.

MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

18 OCT. 2012

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION
 TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

DATE

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

ALUMINUM SHEET 6061 T6
.0810 Nom X 48.0000" X 144.0000"
PART NO.

PO/Ref 18068

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Certificate of Mill Test Results

BL PEC-789038-013

9Oct12

Pg 1/2

Signed by: _____



Abnahmeprüfzeugnis 3.1 (EN 10204) Inspection certificate – mill certificate

Nr.: 85289222 02 / 7

Rev. 0

Seite / page: 1 von / of 2

Datum / date: 2012 02 15

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, EN/AS 9100, ISO 14001, NADCAP

| | |
|---|--|
| Auftraggeber / customer: ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 5C6 CONCORD, ON Warenempfänger / consignee: ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 5C6 CONCORD, ON Endkunde, Bestell-Nr. / Your cust., ord. no.: | Bestell Nr. / order no.: PEC-236262 Datum / date: 2012 01 19 |
| | Auftragsbest. Nr. / order confirm. no.: 636296 Datum / date: 2012 01 20 |
| | Lieferschein Nr. / delivery note: 85289222 Datum / date: 2012 02 29 |
| | Akkreditiv Nr. / letter of credit no.: |

| | |
|--|--|
| Produkt/product Form / form: Sheet Werkstoff / material: 6061 Zustand / temper: T6 Dim. / dim: [inch]: 0,080x48,00x144,00 Kundenartikel-Nr / customer article no.: | Bedingungen/terms: Techn. Lieferbedingungen / techn. spec.: AMS-QQ-A-250/11, 08.1997 ASTM B 209 - 07 Material meets also the mech. properties of AMS 4027N, 07.2008, but not marked ANSI H35.2-2009 ASME SB 209, 2007 Sondervorschrift / special terms: |
|--|--|

| AB-Pos. ord.-item. | BNr/Los/Tellos Lot/No./Part | Guss Nr. cast no. | Werkstoff material | Kollo. packno. | Gewicht netto weight net | Stk. pcs. |
|-----------------------|--------------------------------|----------------------|-----------------------|-------------------|-----------------------------|--------------|
| 02 | 25872/01/00 | 01/0047294/1 | 6061.1 | 6362960002 | 4029,982 lbs | 77 |

| Chemische Zusammensetzung / chemical composition: [%] Gewichtsanteile / weight proportion (OES) | | | | | | | | | | | |
|---|------------------|------|------|------|------|------|------|------|------|------|--|
| Guss Nr. / cast no. | AMAG designation | Si | Fe | Cu | Mn | Mg | Cr | Ni | Zn | Ti | |
| 01/0047294/1 | 6061.1 | | | | | | | | | | |
| | actual | 0,65 | 0,48 | 0,23 | 0,11 | 0,91 | 0,18 | 0,01 | 0,04 | 0,06 | |

| Zugversuch / Tensile test | | | | | | | | | | |
|---------------------------|-------------------|-----------------------|--|--|-------------|----------------|------------|--|--|--|
| BNr/Los Lot/No. | Zustand temper | Richtung direction | | | Rm [ksi] | Rp0.2 [ksi] | A2" [%] | | | |
| 25872/01 | T6 | LT | | | 47,0 | 39,2 | 16 | | | |
| 25872/01 | T6 | LT | | | 47,1 | 39,2 | 15 | | | |
| 25872/01 | T6 | LT | | | 47,3 | 39,3 | 15 | | | |
| 25872/01 | T6 | LT | | | 47,0 | 39,2 | 16 | | | |
| 25872/01 | T6 | LT | | | 46,8 | 39,0 | 16 | | | |
| 25872/01 | T6 | LT | | | 46,7 | 38,9 | 15 | | | |
| 25872/01 | T6 | LT | | | 46,7 | 38,9 | 15 | | | |
| 25872/01 | T6 | LT | | | 46,8 | 39,0 | 16 | | | |
| 25872/01 | T6 | LT | | | 46,6 | 38,7 | 15 | | | |

Das
14
2-89 12/10/11

AMAG rolling GmbH, Postfach 32, A-5282 Ranshofen, Österreich – www.amag.at
AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria – www.amag.at



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18068

Purchase Order Date 10/04/12

PO Print Date 10/04/12

Page Number 5 of 6

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Contact Name

Vendor Phone

905 669 9444

Vendor Fax

905 738 9033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

| | | | | | | | |
|----|---------------------|--------------------|-----------------|--------------|-----------|----------|----------|
| 13 | M6061T6S.080 021 | 6061-T6 .080 Sheet | 10/10/12 Yes | 288.00 sf | Yours ppd | \$2.6764 | \$770.80 |
|----|---------------------|--------------------|-----------------|--------------|-----------|----------|----------|

Special Inst:

MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

| | | | | | | | |
|----|---------------------|--------------------|-----------------|-------------|-----------|----------|----------|
| 14 | M6061T6S.090 021 | 6061-T6 .090 Sheet | 10/10/12 Yes | 96.00 sf | Yours ppd | \$3.0109 | \$289.05 |
|----|---------------------|--------------------|-----------------|-------------|-----------|----------|----------|

Special Inst:

MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

| | | | | | | | |
|----|---------------------|--------------------|-----------------|--------------|-----------|----------|----------|
| 15 | M6061T6S.125 021 | 6061-T6 .125 Sheet | 10/10/12 Yes | 144.00 sf | Yours ppd | \$4.1288 | \$594.55 |
|----|---------------------|--------------------|-----------------|--------------|-----------|----------|----------|

Special Inst:

MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

| | | | | | | | |
|----|---------------|--------------------|-----------------|-------------|-----------|-----------|----------|
| 16 | M2024T3S0.190 | 2024-T3 .190 sheet | 10/10/12 Yes | 48.00 sf | Yours ppd | \$13.9583 | \$670.00 |
|----|---------------|--------------------|-----------------|-------------|-----------|-----------|----------|

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required YES NO

Change Nbr: 2

Change Date: 10/04/12

